

DEPARTMENT OF TRANSPORTATION**DIVISION OF ENGINEERING SERVICES**

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch

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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:**Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-002055**Date Inspected:** 11-Dec-2007**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1500**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Ma Yun**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** OBG Components**Summary of Items Observed:**

The Caltrans Quality Assurance Inspector (QA), M. Paul Stovall, was present at Zhenhua Port Machinery Company (Z. P. M. C.), Changxing Island, Shanghai, China for the purpose of monitoring the fabrication of the SAS/San Francisco/Oakland Bay Bridge.

The QA Inspector witnessed the welding of Side Plate 034, Side Plate stiffeners. Z. P. M. C., Quality Control (QC) was present, monitoring and recording the preheat, and WPS variables on these as they were welded.

Plate 64, Side Plate 002-01-007--weld tacks on plate stiffeners--Low Hydrogen Rod and rod ovens are in use, the material is being preheated prior to welding and the preheat temperatures are beng recorded by Z. P. M. C. QC. The Welder is--Han Jianshe--07092004.

Floor Beam 007-04-021-- no counterweights are in use while positioning and welding stiffeners, Z. P. M. C. QC is checking the fit-up tolerances, and they appear to be satisfactory.

Z.P.M.C. personnel ground and cleaned various plate stiffener faying surfaces prior to being welded.

Side Plate 047-01-(015-021)is being welded by Z. P. M. C. Welder Mi Liu-463565, Welding Procedure Specification (WPS)--B-T-2132-2 was uses and the QA Inspector measured 269 amps and 28 volts ---within WPS parameters.

Plate 35A Bottom Plate (BP)5005-01-(013-012) welded by Z. P. M. C. Welder Liu Zihong - #062447, Z. P. M. C.

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QC personnel are adequately monitoring the work that is being performed.

Summary of Conversations:

The Caltrans QA Inspector was informed by Z. P. M. C. QC Inspector Lay Chow Ton that Magnetic Particle Testing and Ultrasonic Testing would be performed by Z. P. M. C. QC personnel on Skin E, 114 meter Mock-Up, at approximately 3 pm.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Mazen Wahbeh, (818) 292-0659, who represents the Office of Structural Materials for your project.

Inspected By:	Stovall,Paul	Quality Assurance Inspector
Reviewed By:	Cochran,Jim	QA Reviewer
